

Work Order ID 69037

Wednesday, April 27, 2011 11:01:02 AM

Page 1

Item ID: D4171-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 4/27/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4171

A

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg & Folio FA963
2-Deburr

11/5/10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/5/10

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69037

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Page 2

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: B5

0.00



Packaging

Memo

0.00

Packaging

11/5/11 SP (2,1)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 [Signature]

u 16.05-4

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 11:01:10 AM

Page 1

Work Order ID: 69037

Parent Item: D4171-1

Parent Item Name: Bushing




Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000  303 Round Bar 1.00		Purchased	No			100	f	6.3970	0.08	1.684211			

Location

Loc Qty

Loc Code

MAT028

6.397

6.397

~~116700~~

117598

1.68

SH 11/5/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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DART AEROSPACE LTD		Work Order: 69637
Description: Bushing		Part Number: D4171-1
Inspection Dwg: D4171	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	0.752	/		SK-9	
0.540	+/-0.010	0.542	/			
0.210	+/-0.010	0.211	/			
0.150	+/-0.010	0.153	/			
Ø0.305	+0.000/-0.002	0.3035	/		SK-5	
R0.010	+/-0.010	R0.01	/			
0.060	+/-0.010	0.058	/			
0.395	+0.015/-0.005	0.399	/			
0.563	+0.002/-0.015	0.553	/			
Ø0.88	+/-0.030	0.887	/			
Ø0.191	+0.005/-0.001	0.152	/			
R0.063	+/-0.010	R0.063	/		R.G.	
R0.060	+/-0.010	R0.060	/			
45°	+/-0.5°	45°	/			
0.023	+0.030/-0.010	0.025	/			
0.030 x 20°	+/-0.010 x 0.5°	0.030 x 20°	/			

Measured by: [Signature]	Audited by: J.A	Preliminary Approval:
Date: 11/5/10	Date: 11/05/11	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ [Signature]	[Signature]

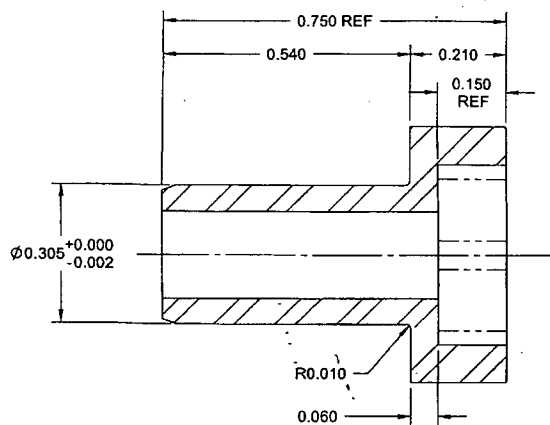
W/O:		WORK ORDER CHANGES						
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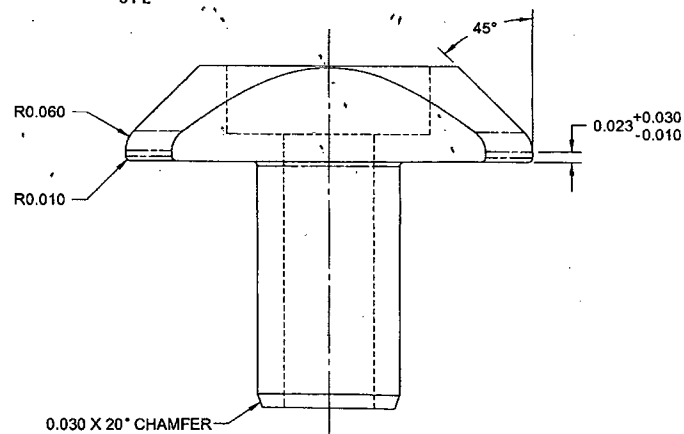
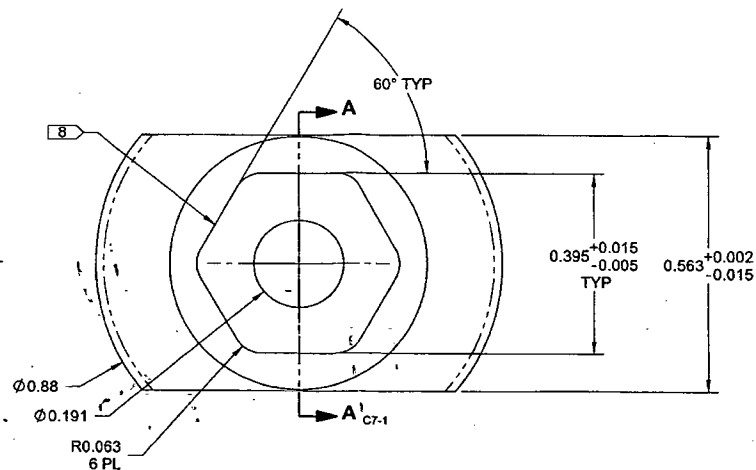
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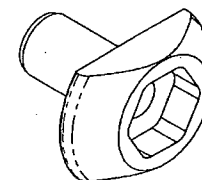
C4-1 **SECTION A-A**



D4171-1 BUSHING

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) HEXAGON/HOLE MUST ALLOW INSERTION OF AN3 BOLT.



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69037

01104-27

RELEASED
2010-09-15
JM

REV.	NEW ISSUE	DESCRIPTION	CP	10.08.26
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.08.26			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D4171	SHEET 1 OF 1
TITLE BUSHING	SCALE NTS
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